<u> </u>										
Work Order ID Thursday, March 03, 201										Page 1
Item ID: D3278-IRevision ID: Item Name: Support			ccept				s	etup Star Sto		
Start Date: 3/3/2011 Required Date: 3/11/201 Reference:				Cust Item II Customer:	D:					
Approvals: Process QC:	s Plan:	Date:	Tooling: _ SPC (Y/N):		te:		R	un Star Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3278	Revision Nbr Rev C			*						
100 	BAND SAW Memo Cut blank	:: 2.00" x 1.00" x 2.550" long	0.00 m	11/03/16			40	<i>-</i> 8		
110 		AL MACHINING #1 ne as per Folio FA405 and Dwg Identify as D3278-1	0.00 0.00 D3278□2- Deburr and	L 11/03/17		đ.	40	<i>9</i>		

120

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00 Onl 11/03/12

40 Ø _____

Quality Control

0.00

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval **Approval STEP** DATE PROCEDURE CHANGE By Date Qty Chief Eng / QC Inspector Prod Mgr Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification Approval Approval DATE **STEP** Sign & **Action Description** Initial Section A Section C Chief Eng QC Inspector Date Chief Eng Chief Eng

Thursday, March 03, 2011 8:46:44 AM

Item ID:

D3278-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Support

3/3/2011

QC:

Start Qty: 40.00

Req'd Qty: 40.00

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 3/11/2011

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID**

130

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours** 0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish Hand Finishing Memo

0.00

BR 11-3-21.

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo START TIME:

0.00

□OVEN TEMPERATURE:

_□FINISH TIME:

										_
W/O:	V/O:			WORK ORDER C	HANGES					
DATE	STEP	PRO	OCEDURE CI	HANGE		Ву	Date C	ity Ch	proval ief Eng / rod Mgr	Approval QC Inspector
					-					
Part No		PAR #:	Fault Ca	ategory:	NC	R: Yes	No DQA:		Date: _	
		solution:		,						
NCR:			WORK OR	DER NON-CONF	ORMANC	(NCR)			
DATE	CTED	Description of NC		Corrective Action Section B			Verificati	on An	proval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descr Chief Eng	ription	Sign & Date	Section (hief Eng	QC Inspector
		•								and the state of t
		,								
				*						

Item ID:

D3278-1

Thursday, March 03, 2011 8:46:44 AM

Accept



Setup Start



Revision ID:

Item Name: **Start Date:**

Support

3/3/2011

QC:

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 3/11/2011

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ **Run Hours**

0.00

0.00

Date:

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

40 Bl 11-3-22

170

Packaging

Packaging

Memo

0.00

SB 11/03/23

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location.

0.00

Memo

Memo

0.00

W/O:	-		WO	RK ORDER CI	HANGES					
DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cated	jory:	NC.	R: Yes	No DQA :		Date:	
		olution:								
NCR:			WORK ORDE	R NON-CONF	ORMANCE	(NCR)			
DATE	STEP	Description of NC	Initial	Section B	Sign &	Verifica		Approval	Approva	
		Section A	Chief Eng	Action Descr Chief Eng		Date	Section	С	Chief Eng	QC Inspector
										,
	7						**			

Picklist Print

Thursday, March 03, 2011 8:46:52 AM

Work Order ID: 66948

Parent Item: D3278-1

Parent Item Name: Support

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: □A□04.04.19□New issue□KJ/JLM□

rev.c dwg EC verified by: JLM IPP B 07.09.06

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00		Purchased	No			001	f	53.4303	0.2337	9.84			

6061-T6 Bar 1.00 x 2.00

Location	Loc Oty	Loc Code	
MAT	51.972		
112567	0		
114415	3.75		****
115045	3.902		
115952	40		9.84
116623	4.32		
MAT03	1.4583		
112567	1.4583		***************************************

Page 1

											
W/O:			WORK ORDER CHANGES								
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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11949355						***************************************					
Part No	*	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA	i:	_ Date: _			
	Resolution:		Disposition	n:	_ QA: N/C C	losed:		Date: _			
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCF	₹)					
DATE	STEP	Description of NC		on B	Verifica		Approval	Approva			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		n C	Chief Eng	QC Inspector		
		-									
	·			-							

DART AEROSPACE LTD	Work Order:	46948
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø.099			Vern ML	-7
0.359	+/-0.005	1359	_		1 (
0.609	+/-0.010	615			٠,	
0.250	+/-0.010	.250	_		: (
1.480	+/-0.005	1.480			1.	
R0.125	+/-0.010	R.125			Red-gize	
0.119	+0.005/-0.004	1/23			Vern Ml.	7
2.439	+/-0.010	2.437			i,	
1.980	+/-0.010	1.981			71	
R0.13	+/-0.030	R.130			Rad-rase	
Ø0.257	+0.005/-0.000	Ø.258			Vern 9	1- 7
R0.375	+/-0.010	R.375			Rad-gara	
0.875	+/-0.010	.875	_		Vern Fil	7
0.500	+/-0.010	,500			1,	
R0.400	+/-0.010	R.400			Red-san	P
R1.00	+/-0.030	R1.00			1,07	
1.720	+/-0.010	1.750			Verny	V-7
R0.125	+/-0.010	R.125	_		Red-sag	
0.125	+/-0.010	,/25			Vein H	マ

Measured by: Oul	Audited by:	Prototype Approval:	N/A
Date: ///03/18	Date: 1103/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
С	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC 🔏	B
			771	

art	Aer	OS	pace	Ltd

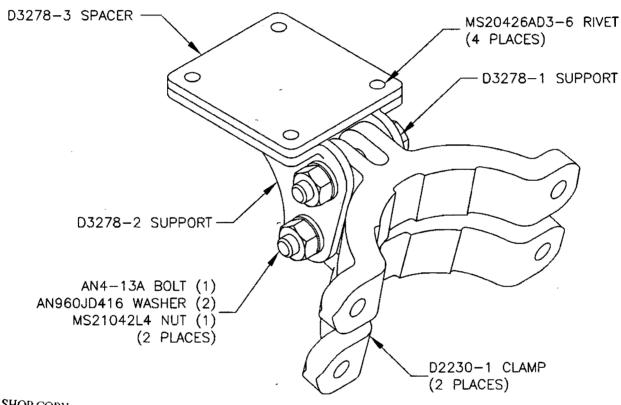
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DATE	0750	Description of NC	Corrective Action Section B			Verifica			Approval	Approval			
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	4) #	D3278 SHEET	1 OF 3			
DATE			TITLE	SCALE			
07.0	7.24		SUPPORT ASSEMBLY	NTS			
Α		04.03.03	NEW ISSUE				
В		05.03.31	CHANGE DIM/TOL TO ENSURE FIT				
С		07.07.24	CHANGED RIVETS PER PAR #185				



D3278-041 SUPPORT ASSEMBLY



Pl 11-03-3

Qty	Part Number	Description	
X	D3278-041	SUPPORT ASSEMBLY	
			_
2	D2230-1	CLAMP	
1	D3278-1	SUPPORT	
1 ·	D3278-2	SUPPORT	
1	D3278-3	SPACER	
2	AN4-13A	BOLT	
4	AN960JD416	WASHER	
4	MS20426AD3-6	RIVET	
2	MS21042L4	NUT	

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DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval
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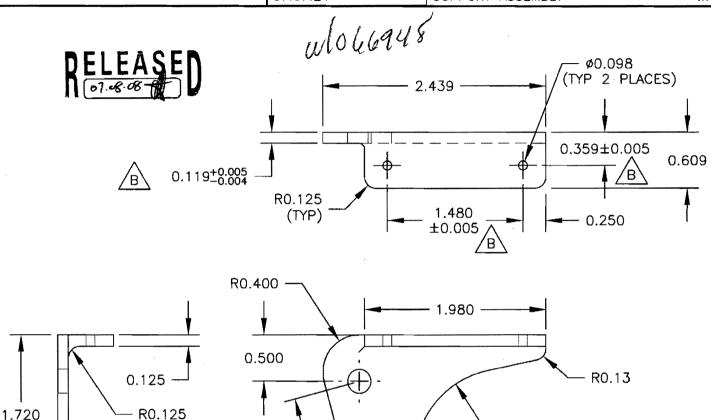


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DATE		TITLE		SCA	LE
07.07.24		SUPPORT ASSEMBLY		1	1:1

R1.00

Ø0.257

(TYP 2 PLACES)



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

0.875

R0.375

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

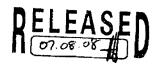
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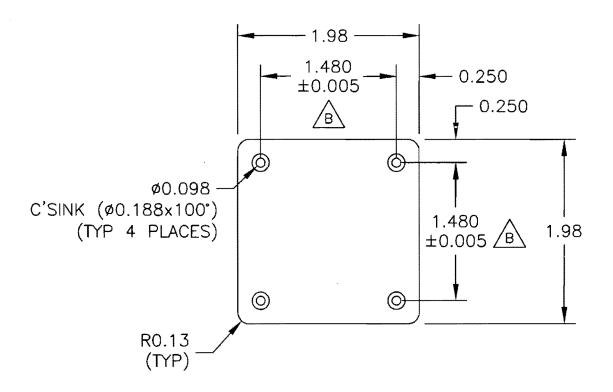
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NCR:		,	WORK ORD	ER NON-CONFORM	MANCE	(NCR))			
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			Initial Chief Eng	Action Description Chief Eng		Date	Section	on C	Chief Eng	QC Inspector



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DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



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D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

 (REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

 DELRIN II 150E OR ACETRON GP ACETAL

 (REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE	STEP	Description of NC	Description of NC Corrective Action		on B	Verification	1 Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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